

Work Order ID 68528

Thursday, April 14, 2011 3:57:01 PM



Page 1

Item ID: D3935-3

Accept



Setup Start



Revision ID:

Item Name: Pylon Wall Protector, LH

Stop



Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 4/14/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3935

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3935

Dwg Rev: *B*

Prog Rev: *B*

2- Deburr if necessary

0.00

B 11-4-18

[Signature] 4/14/11

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 11-4-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Stop



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Start Date: 4/14/2011 Start Qty: 2.00



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Required Date: 4/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Swey 1/8

Quality Control



130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

PPP 68531

Packaging

4/14/11

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/14/11
MF
11-04-19

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Picklist Print

Thursday, April 14, 2011 3:57:07 PM

Page 1

Work Order ID: 68528



Parent Item: D3935-3



Parent Item Name: Pylon Wall Protector, LH

Start Date: 4/14/2011

Required Date: 4/20/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,652.715	8.5323	17.96274			
GE PLASTICS LEXAN SHEET													

RB11-4-18

Location

Loc Qty

Loc Code

MAT018

2652.715789

115261

632

116236

2020.71579

115261



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DART AEROSPACE LTD		Work Order:	68528
Description: Pylon Wall Protector, LH		Part Number:	D3935-3
Inspection Dwg: D3935	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.68	+/-0.030	5.68	X		T B01	
12.68	+/-0.030	12.68	X		T	
18.75	+/-0.030	18.75	X		T	
19.00	+/-0.030	19.00	X		T	
20.25	+/-0.030	20.25	X		T	
22.75	+/-0.030	22.75	X		T	
23.73	+/-0.030	23.73	X		T	
28.63	+/-0.030	28.63	X		T	
32.75	+/-0.030	32.75	X		T	
1.00	+/-0.030	1.00	X		T	
3.50	+/-0.030	3.50	X		T	
9.00	+/-0.030	9.00	X		T	
17.00	+/-0.030	17.00	X		T	
18.50	+/-0.030	18.50	X		T	
33.40	+/-0.030	33.40	X		T	
34.25	+/-0.030	34.25	X		T	
34.60	+/-0.030	34.60	X		T	
34.72	+/-0.030	34.72	X		T	
22.85	+/-0.030	22.85	X		T	
19.15	+/-0.030	19.15	X		T	
35.39	+/-0.030	35.39	X		T	
0.125	+/-0.010	0.125	X		V B02	

Measured by:	B
Date:	11-4-18

Audited by:	S
Date:	11/04/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.17	New Issue	KJ	

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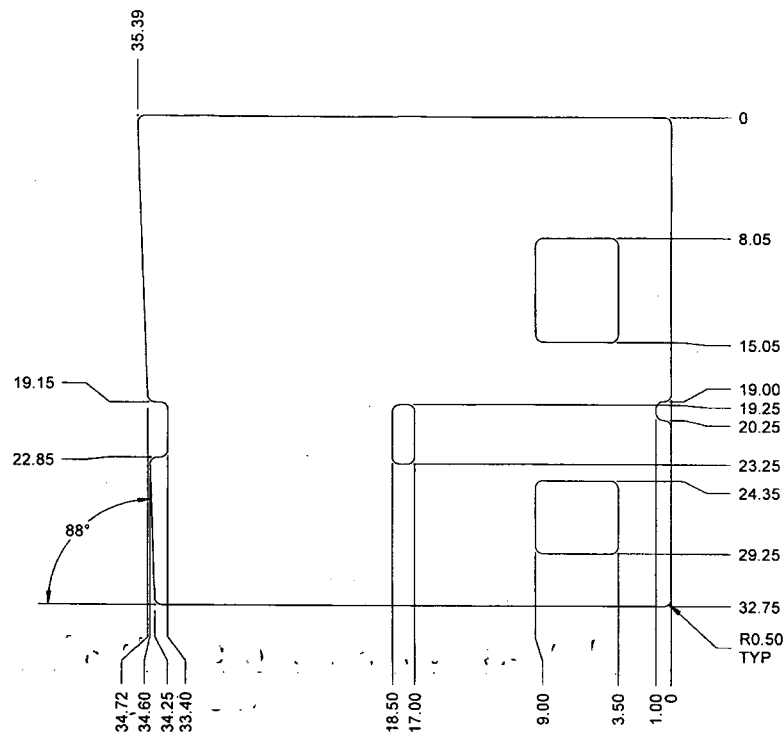
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68528

011-04-14

0.125
REF



D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

RELEASED
2009-10-22
AM

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

B	ADD -3, -4 (SHEET 3, 4)	09.08.19
A	NEW ISSUE	HS 09.04.21
REV.	DESCRIPTION	BY DATE
DESIGN	05	
DRAWN	05	
CHECKED	PH	
MFG. APPR.	DS	
APPROVED	140	
DE APPR.	04	
DATE	09.08.19	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D3935		
TITLE PYLON PROTECTOR		
REV. B SHEET 1 OF 4 SCALE NTS		
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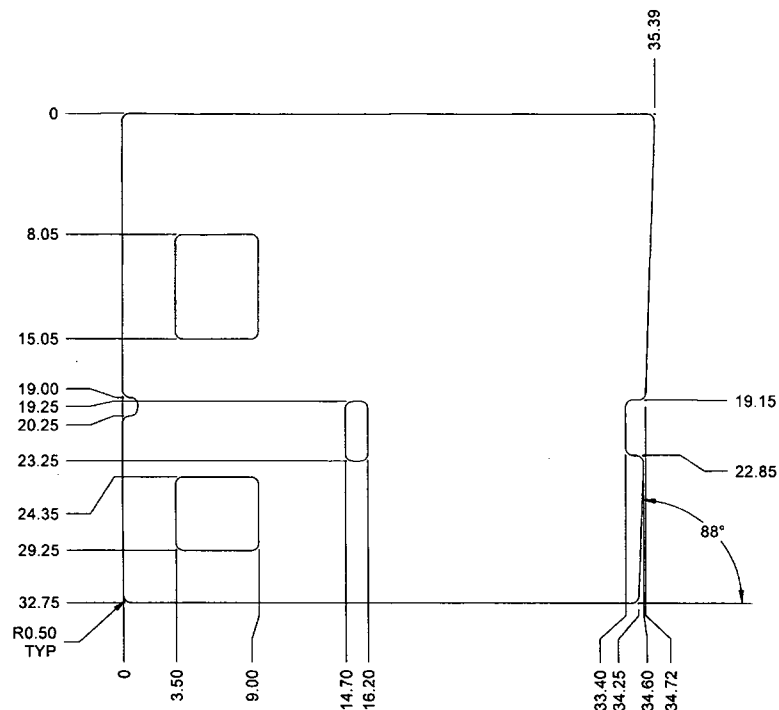
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NOTE: Date & initial all entries



D3935-2 PYLON WALL PROTECTOR, RH
(TEXTURED SIDE SHOWN)

RELEASED
2009 -10-22
ND

w/o 68525

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8923

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3935	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PYLON PROTECTOR	NTS
DATE	09.08.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

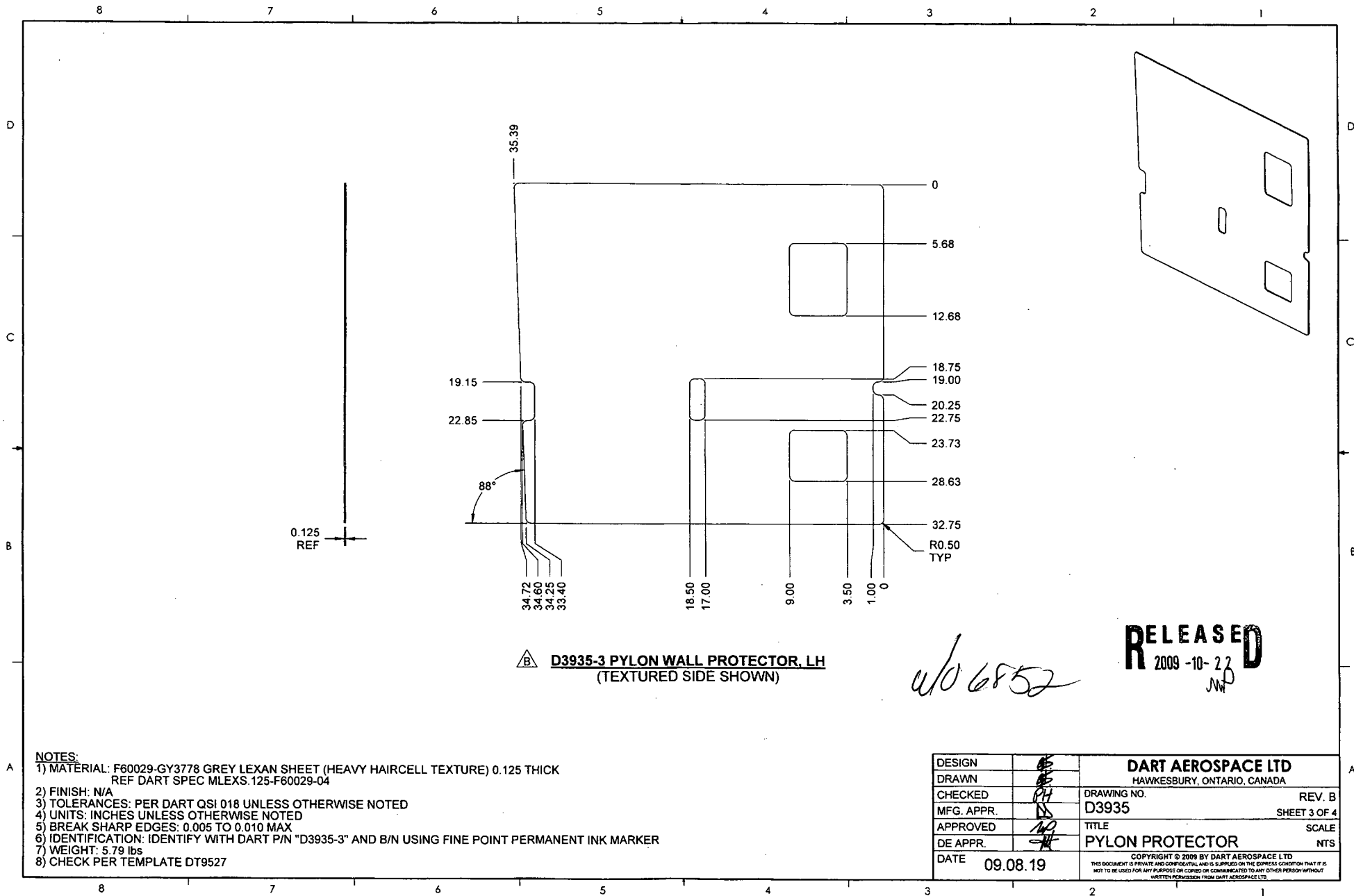
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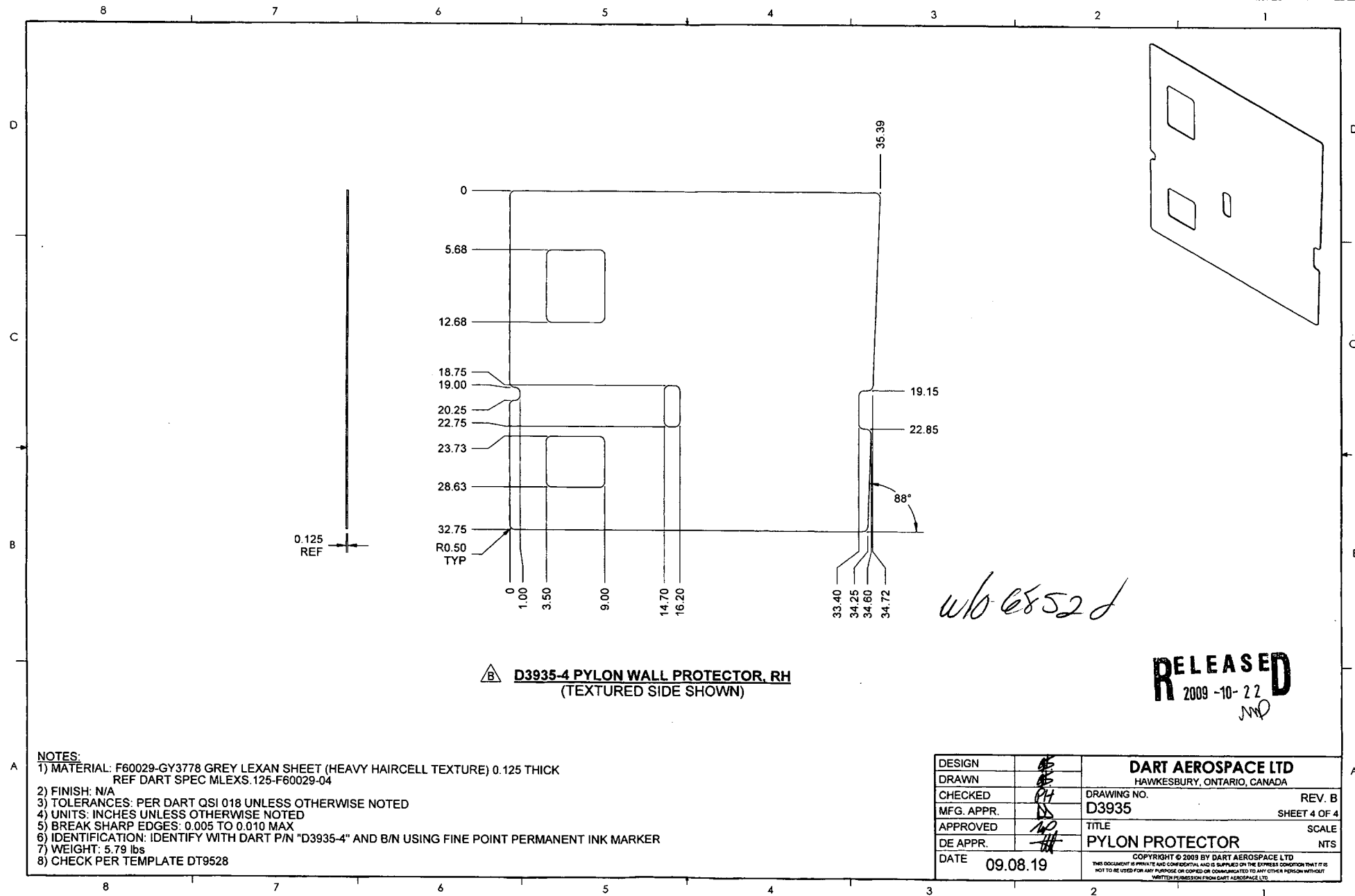
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